

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023473**Date Inspected:** 08-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

This QA Inspector observed the following work in progress:

OBG Seg 14E:

Repair welding of weld joint no: Seg3019*-004 [Deck Panel (DP) 3159 to DP3160, complete joint penetration (CJP) weld]. The welder is identified as 066773 and was observed welding in the 1G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC Quality Control (QC) was identified as Zhu Yuan Yuan. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): 345-SMAW-1G(1F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): B-WR 20948 Rev-0.

This QA Inspector verified the following Critical Welding Report's (CWR):

1) B-CWR 2966 Rev-0 Dt: 06/05/11 (for UT repair): For weld jt nos: Seg 3019AP-037 and Seg3019AQ-046.

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2) B-CWR 2968 Rev-0 Dt: 05/08/11: For base metal repair after removal of temporary attachments from Seg 13AW, Cross Beam 18 (CB18) and Seg 13AE.

OBG Seg 13AE and Seg 13BE:

ABF personnel performing Magnetic Particle Testing (MT) after removal of temporary attachments at weld jt no: OBE13-002 (DP – DP, CJP splice weld). See attached photo for details.

OBG Seg 13AW and Seg 13BW:

ABF personnel performing MT after completion of hot pass at weld jt no: OBW13-001, 002 and 003.

OBG Seg 13AW:

Repair welding of weld joint no: Seg3013-006(DP3122A to DP3123A, CJP splice weld). The welder is identified as 067609 and was observed welding in the 4G position. Welding process was identified as SMAW. ZPMC QC was identified as Zhang Lin. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair. Repair welding was done as per WRR: B-WR 20828 Rev-0.

OBG Seg 13CW:

Repair welding of weld joint no: AH3003D-001 [Edge Panel (EP) 3026A to Side Panel (SP) 3115A, CJP weld]. The welder is identified as 045196 and was observed welding in the 2G position. Welding process was identified as SMAW. ZPMC QC was identified as Sun Tian Ling. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per WRR: B-WR 20881 Rev-0.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable Contract documents.



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Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By:	Wadkar,Sailesh
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Quality Assurance Inspector

Reviewed By:	Peterson,Art
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QA Reviewer
